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**D3914-041**  
**Job Sheet 192056**



**Part No:** D3914-041

**Job Qty:** 1 pcs

**Part Name:** Long Basket Lid Assembly (350)



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 3/15/19

**Job Tracking No:**

**Due Date:** 4/15/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC  
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD  
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off  |
|-------|------------------------|----------|------------|----------|-----------|---------|-----------------------|-----------|-----------|
|       |                        |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |
| 100   | Large Fab - Basket - 1 | 1<br>pcs | 4/15/19    |          | 0.00      | 6.67    | Large Fab - 1         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 10        |           |           |
|       |                        |          |            |          |           |         | Large Fab - 2         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 3         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 4         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 5         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 6         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 7         |           |           |
|       |                        |          |            |          |           |         | Large Fab - 8         |           |           |
| 110   | QC 9                   | 1<br>pcs | 4/15/19    |          | 0.00      | 0.00    | Large Fab - 9         |           |           |
|       |                        |          |            |          |           |         | QC 9 - 10             |           |           |
|       |                        |          |            |          |           |         | QC 9 - 18             |           |           |
|       |                        |          |            |          |           |         | QC 9 - 24             |           |           |
|       |                        |          |            |          |           |         | QC 9 - 43             |           | DAS<br>43 |
|       |                        |          |            |          |           |         | QC 9 - 50             |           | 9-89      |
| 120   | QC 5                   | 1<br>pcs | 4/15/19    |          | 0.00      | 0.00    | QC 9 - 9              |           |           |
|       |                        |          |            |          |           |         | QC 5 - 10             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 12             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 17             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 18             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 19             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 22             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 24             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 3              |           |           |
|       |                        |          |            |          |           |         | QC 5 - 42             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 43             |           | DAS<br>43 |
|       |                        |          |            |          |           |         | QC 5 - 49             |           | 9-89      |
|       |                        |          |            |          |           |         | QC 5 - 51             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 58             |           |           |
|       |                        |          |            |          |           |         | QC 5 - 68             |           |           |

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|                                     |       |         |           |  |  |                          |  |
|-------------------------------------|-------|---------|-----------|--|--|--------------------------|--|
|                                     |       |         |           |  |  | QC 5 - 9                 |  |
|                                     |       |         |           |  |  | QC 5 - 50                |  |
|                                     |       |         |           |  |  | QC 5 - 30                |  |
|                                     |       |         |           |  |  | QC 5 - 40                |  |
|                                     |       |         |           |  |  |                          |  |
| 130 Powdercoat - 4 Black Sand - B4B | 1 pcs | 4/15/19 | 0.00 0.40 |  |  | Powdercoat - 1 - B4B     |  |
|                                     |       |         |           |  |  | Powdercoat - 2 - B4B     |  |
|                                     |       |         |           |  |  | Powdercoat - 3 - B4B     |  |
|                                     |       |         |           |  |  | Powdercoat - 4 - B4B     |  |
|                                     |       |         |           |  |  |                          |  |
| 135 QC 3                            | 1 pcs | 4/15/19 | 0.00 0.00 |  |  | QC 3 - 10                |  |
|                                     |       |         |           |  |  | QC 3 - 13                |  |
|                                     |       |         |           |  |  | QC 3 - 15                |  |
|                                     |       |         |           |  |  | QC 3 - 17                |  |
|                                     |       |         |           |  |  | QC 3 - 18                |  |
|                                     |       |         |           |  |  | QC 3 - 2                 |  |
|                                     |       |         |           |  |  | QC 3 - 28                |  |
|                                     |       |         |           |  |  | QC 3 - 3                 |  |
|                                     |       |         |           |  |  | QC 3 - 30                |  |
|                                     |       |         |           |  |  | QC 3 - 34                |  |
|                                     |       |         |           |  |  | QC 3 - 36                |  |
|                                     |       |         |           |  |  | QC 3 - 41                |  |
|                                     |       |         |           |  |  | QC 3 - 51                |  |
|                                     |       |         |           |  |  | QC 3 - 58                |  |
|                                     |       |         |           |  |  | QC 3 - 59                |  |
|                                     |       |         |           |  |  | QC 3 - 68                |  |
|                                     |       |         |           |  |  | QC 3 - 9                 |  |
|                                     |       |         |           |  |  | QC 3 - 40                |  |
|                                     |       |         |           |  |  | QC 3 - 19                |  |
|                                     |       |         |           |  |  |                          |  |
| 140 Handfinish - 3-1- WingWalk-B4B  | 1 pcs | 4/15/19 | 0.00 0.80 |  |  | Handfinish - 3 - 1 - B4B |  |
|                                     |       |         |           |  |  | Handfinish - 3 - 2 - B4B |  |
|                                     |       |         |           |  |  | Handfinish - 3 - 3 - B4B |  |
|                                     |       |         |           |  |  | Handfinish - 3 - 4 - B4B |  |
|                                     |       |         |           |  |  | Handfinish - 3 - 5 - B4B |  |
| 150 QC 3                            | 1 pcs | 4/15/19 | 0.00 0.00 |  |  | QC 3 - 10                |  |
|                                     |       |         |           |  |  | QC 3 - 13                |  |
|                                     |       |         |           |  |  | QC 3 - 15                |  |
|                                     |       |         |           |  |  | QC 3 - 17                |  |
|                                     |       |         |           |  |  | QC 3 - 18                |  |
|                                     |       |         |           |  |  | QC 3 - 2                 |  |
|                                     |       |         |           |  |  | QC 3 - 28                |  |
|                                     |       |         |           |  |  | QC 3 - 3                 |  |
|                                     |       |         |           |  |  | QC 3 - 30                |  |
|                                     |       |         |           |  |  | QC 3 - 34                |  |
|                                     |       |         |           |  |  | QC 3 - 36                |  |
|                                     |       |         |           |  |  | QC 3 - 41                |  |
|                                     |       |         |           |  |  | QC 3 - 51                |  |
|                                     |       |         |           |  |  | QC 3 - 58                |  |
|                                     |       |         |           |  |  | QC 3 - 59                |  |
|                                     |       |         |           |  |  | QC 3 - 68                |  |
|                                     |       |         |           |  |  | QC 3 - 9                 |  |
|                                     |       |         |           |  |  | QC 3 - 40                |  |
|                                     |       |         |           |  |  | QC 3 - 19                |  |
|                                     |       |         |           |  |  |                          |  |
| 160 Packaging 3-1 - Stock - B4B     | 1 pcs | 4/15/19 | 0.00 0.00 |  |  | Packaging 3 - 1 - B4B    |  |
|                                     |       |         |           |  |  | Packaging 3 - 2 - B4B    |  |
|                                     |       |         |           |  |  | Packaging 3 - 3 - B4B    |  |
|                                     |       |         |           |  |  | Packaging 3 - 4 - B4B    |  |

DAS  
15  
9-89

DAS  
19  
9-03

|                                                                                                                                                                                                                                                        |     |         |           |                        |                |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|---------|-----------|------------------------|----------------|
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 5 - B4B  |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 6 - B4B  |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 7 - B4B  |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 8 - B4B  |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 9 - B4B  |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 10 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 11 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 12 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 13 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 14 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 15 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 16 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 17 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 18 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 19 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 20 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 21 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 22 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 23 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 24 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 25 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 26 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 27 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 28 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 29 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 30 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 31 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 32 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 33 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 34 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 35 - B4B |                |
|                                                                                                                                                                                                                                                        |     |         |           | Packaging 3 - 36 - B4B |                |
| 170 QC 21 - SA                                                                                                                                                                                                                                         | 1   | 4/15/19 | 0.00 0.00 | QC 21 - SA - 21        | DAS            |
|                                                                                                                                                                                                                                                        | pcs |         |           | QC 21 - SA - 70        | 21 APR 01 2019 |
|                                                                                                                                                                                                                                                        |     |         |           | QC 21 - SA - 53        | 9-89           |
| Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld<br>Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on |     |         |           |                        |                |



basket as per dwg D3914 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 \*\*\* mask sides of hinge prior to powdercoat\*\*\*

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch \_\_\_\_\_ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg \*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: \_\_\_\_\_

170 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item | Component Name                     | Quantity       | Operation                  | Container |
|-------------|------------------------------------|----------------|----------------------------|-----------|
| D2581 ✓     | Mounting Bracket                   | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5155219   |
| D3914-1 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5163815   |
| D3914-7 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5163656   |
| D4016-3 ✓   | Hinge Half, Lid                    | 3 pcs (3 ea) ✓ | 100-Large Fab - Basket - 1 | 5110937   |
| D4018-5 ✓   | Rib                                | 9 pcs (9 ea) ✓ | 100-Large Fab - Basket - 1 | 5161565   |
| D4020-5 ✓   | Mesh (350 Basket Long, Lid)        | 1 pcs (1 ea) ✓ | 100-Large Fab - Basket - 1 | 5164363   |
| D4021-3 ✓   | Data Plate                         | 1 pcs (1 ea) ✓ | 100-Large Fab - Basket - 1 | 5154112   |
| D4035-043 ✓ | Lid Rib Assembly, Aft (350 Basket) | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5163793   |

### Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 100-Large Fab - Basket - 1 | D2581          | 2        | 99        | 0         |
|                            | D3914-1        | 2        | 4         | 0         |
|                            | D3914-7        | 2        | 4         | 0         |
|                            | D4016-3        | 3        | 108       | 0         |
|                            | D4018-5        | 9        | 57        | 0         |
|                            | D4020-5        | 1        | 1         | 0         |
|                            | D4021-3        | 1        | 15        | 0         |
|                            | D4035-043      | 2        | 6         | 0         |

### Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



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Container No: S167173



Part: D3914-041

Job No: 192056

Serial No/Batch: S167173

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/28/19